

78561

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

20

Cust Item ID:

20

Customer:

Reference:

Run Start *NR1*

Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78561

78561

Page 2

January-11-12 10:57:37 AM

Item ID: D2893-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 2.75 Support
 Start Date: 11/01/2012 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 10/02/2012 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
HandFXtube	Memo	0.00							
Hand Finishing Crosstubes	Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24h of cure time.								
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.00							
Packaging									

AR 12 - 2 - 15 (20)

W 12 02 16 (20)

AR 12 - 2 - 16 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78561***78561***

Page 3

January-11-12 10:57:37 AM

Item ID: D2893-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 2.75 Support
Start Date: 11/01/2012 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 10/02/2012 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

Handwritten: 12/02/16 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-11-12 10:57:41 AM

Page 1

Work Order ID: 78561

78561

Parent Item: D2893-1

D2893-1

Parent Item Name: 2.75 Support

Start Date: 11/01/2012

Required Date: 10/02/2012

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP: C02.11.26Reformat; Added P/OKJ

IPP D 06.04.19 removed alodine EC

IPP Rev:E Added priming as per Rev B 07-04-30 JLM

IPP F 08.03.19 Re-format EC verified by: DD

IPP Rev:G 08-05-15 add QC14 DD verified by:EC

IPP Rev:H

11.08.04 as per dwg rev.C DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK078		Manufactured	No			100	Each	0.0000	0.5	10.52632			

DSK078

D2893-1 TURNING DETAIL

**

29 12.2.13

Location

Loc Qty

Loc Code

MAT

-10

MAT060

10

78443

10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	78561
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		3.300	3.303	2.997	2.995	2.997
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.135	.135	.135	.135	.131
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.190	.190	.190	.190	.190
AF	0.125	0.160		.140	.140	.140	.140	.140
AG	0.140	0.160		.148	.150	.149	.149	.148
AH	1.360	1.400		1.380	1.376	1.373	1.377	1.372
AI	0.040	0.060		.046	.053	.055	.050	.049
AJ	1.190	1.230		1.220	1.220	1.221	1.221	1.217
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.525	2.525	2.530	2.530	2.530
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by:	JL	Date:	12-02-10
Audited by:	AK	Date:	12/02/14
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	78561
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: <i>BC</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.995	2.995	2.997	2.997	2.997
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.131	.134	.134	.134	.134
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.190	.187	.187	.187	.187
AF	0.125	0.160		.140	.144	.144	.144	.144
AG	0.140	0.160		.150	.146	.148	.145	.144
AH	1.360	1.400		1.375	1.380	1.375	1.382	1.382
AI	0.040	0.060		.051	.041	.044	.041	.040
AJ	1.190	1.230		1.220	1.217	1.216	1.215	1.218
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.530	2.530	2.530	2.530	2.530
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by:	<i>JK / RQ</i>	Date:	12-02-10
Audited by:	<i>cmz</i>	Date:	12/02/14
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	78561
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.997	2.996	2.996	2.996	2.994
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.134	.134	.134	.134	.134
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.189	.189	.189	.189	.189
AF	0.125	0.160		.140	.140	.140	.140	.140
AG	0.140	0.160		.145	.145	.146	.147	.147
AH	1.360	1.400		1.380	1.377	1.381	1.382	1.382
AI	0.040	0.060		.044	.045	.043	.043	.046
AJ	1.190	1.230		1.222	1.247	1.220	1.220	1.220
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.530	2.530	2.530	2.530	2.530
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.260	.260	.260	.260	.260
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by: RP

Date: 12.2.12

Audited by: SM

Date: 12/02/14

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order:	78561
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

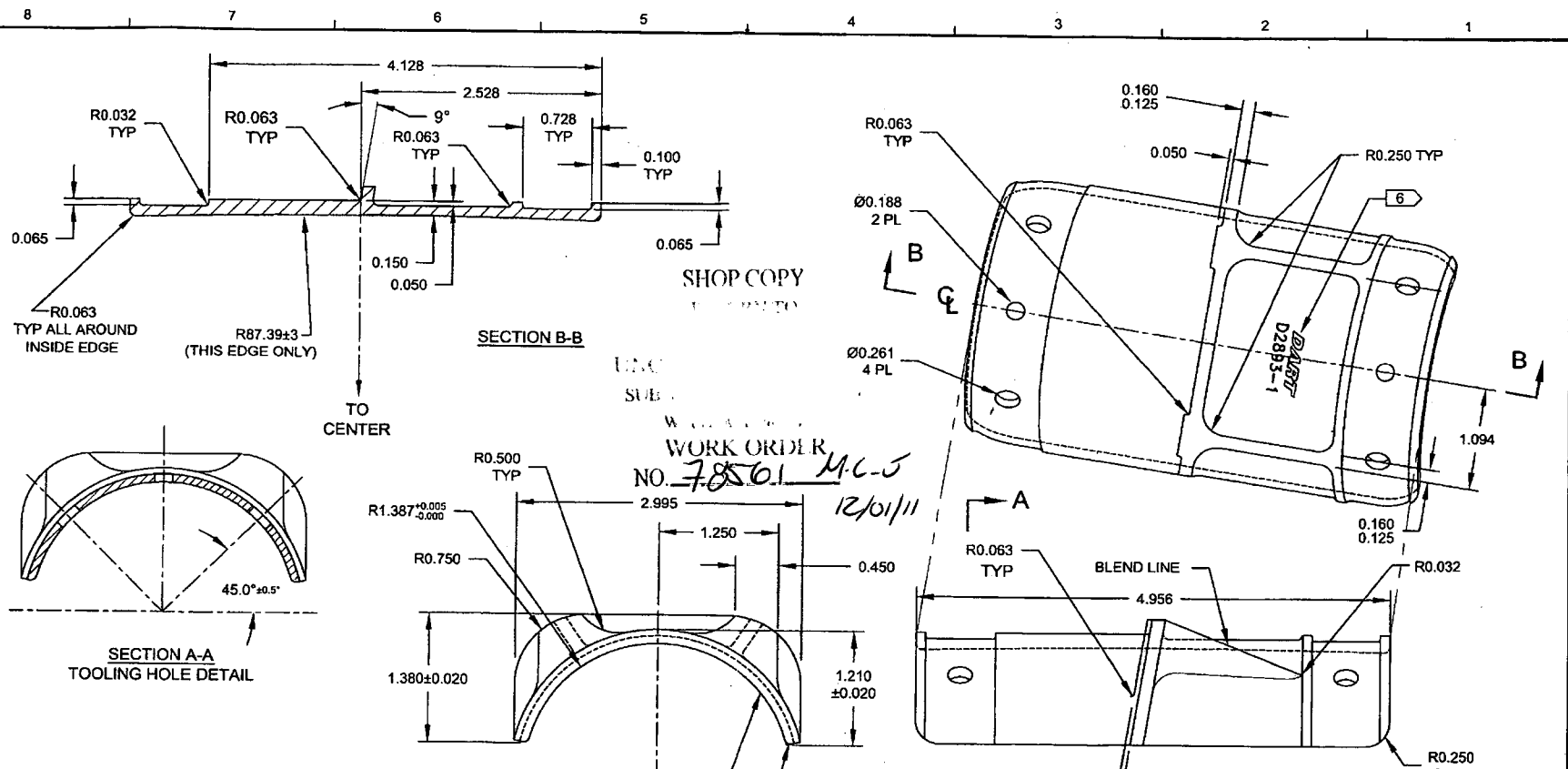
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.997	2.997	2.997	2.997	2.997
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.134	.134	.134	.134	.134
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.189	.189	.189	.189	.189
AF	0.125	0.160		.140	.140	.140	.140	.140
AG	0.140	0.160	✓	.148	.146	.148	.148	.148
AH	1.360	1.400	✓	1.380	1.378	1.378	1.376	1.375
AI	0.040	0.060	✓	.043	.044	.045	.047	.048
AJ	1.190	1.230	✓	1.218	1.216	1.218	1.219	1.215
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.530	2.530	2.530	2.530	2.530
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.260	.260	.260	.260	.260
AQ	0.053	0.073		.063	.063	.063	.067	.068
AR								
AS								
AT								
Accept/Reject								

Measured by: Re Date: 12/02/13

Audited by: [Signature] Date: 12/02/14

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	<u>[Signature]</u>



NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRc)
(REF DART SPEC. D6104)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 (REF X.XXX = ±0.010) UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP, PER DART QSI 044 6.3.
- 7) WEIGHT: 0.78 lb
- 8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.

D2893-1 SUPPORT

RELEASED
2011-07-28

C	RMV FINISH, ADD 3M 2216, ADD H925 MAT'L OPTION	CP	11.07.15
B	UPDATE DIMS AS MFG, PRIME INSIDE	PH	07.03.16
A	NEW ISSUE	CP	01.01.10
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.07.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2893
REV. C
SHEET 1 OF 1
TITLE 02.750 SUPPORT
SCALE NTS

COPYRIGHT © 2001 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action , Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries